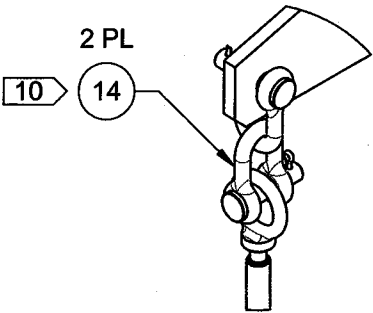
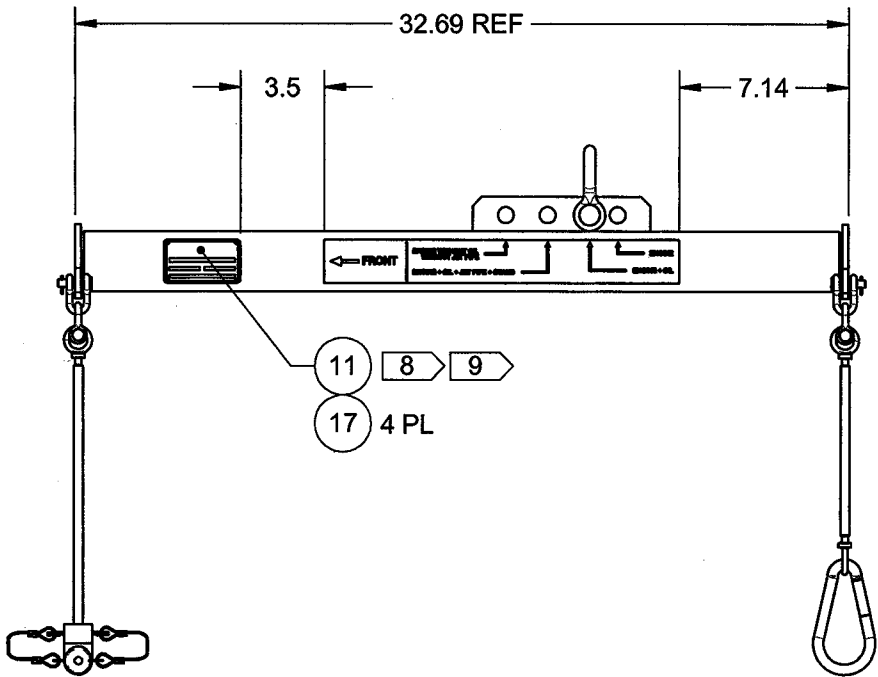


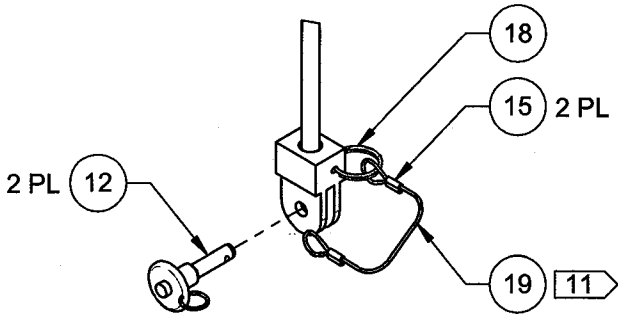
ITEM #	QTY	PART #	PART TITLE
-1	1	RBE332A91-5490-00-1	SLING WELDMENT
-5	2	RBE332A91-5490-00-5	LEFT HAND ROD WELDMENT
-8	2	RBE332A91-5490-00-8	RIGHT HAND ROD WELDMENT
-10	1	RBE332A91-5490-00-10	STICKER
11	1	RB41011	DART PLACARD
12	2	MS17984C508	SS QUICK RELEASE PIN 5/16" DIA. X 0.800" GRIP LG.
13	1	NAS1042-8	ZINC PLATED STEEL ANCHOR SHACKLE 13/16" OPENING WIDTH X 2830 LBS. MAX. WORKING LOAD
14	8	NAS1044-4	ZINC PLATED STEEL CHAIN SHACKLE 15/32" OPENING WIDTH X 710 LBS. MAX. WORKING LOAD
15	4	McMaster#3896T31 OR EQUIV.	ALUMINUM WIRE ROPE COMPRESSION SLEEVE 1/16" DIA. X 3/8" LG.
16	2	McMaster#3933T18 OR EQUIV.	ZINC PLATED STEEL CARABINER 5/8" OPENING WIDTH X 800 LBS. CAPACITY
17	4	McMaster#90081A077 OR EQUIV.	ZINC PLATED STEEL SCREW NAIL #2 SIZE X 1/4" LG.
18	2	McMaster#90905A655 OR EQUIV.	316 SS SPLIT RING 15/16" ID. X 1-1/16" OD. X 1/8" THK.
19	A/R	CARR-LANE#CL-2-C	NYLON COATED STEEL LANYARD 1/16" DIA.



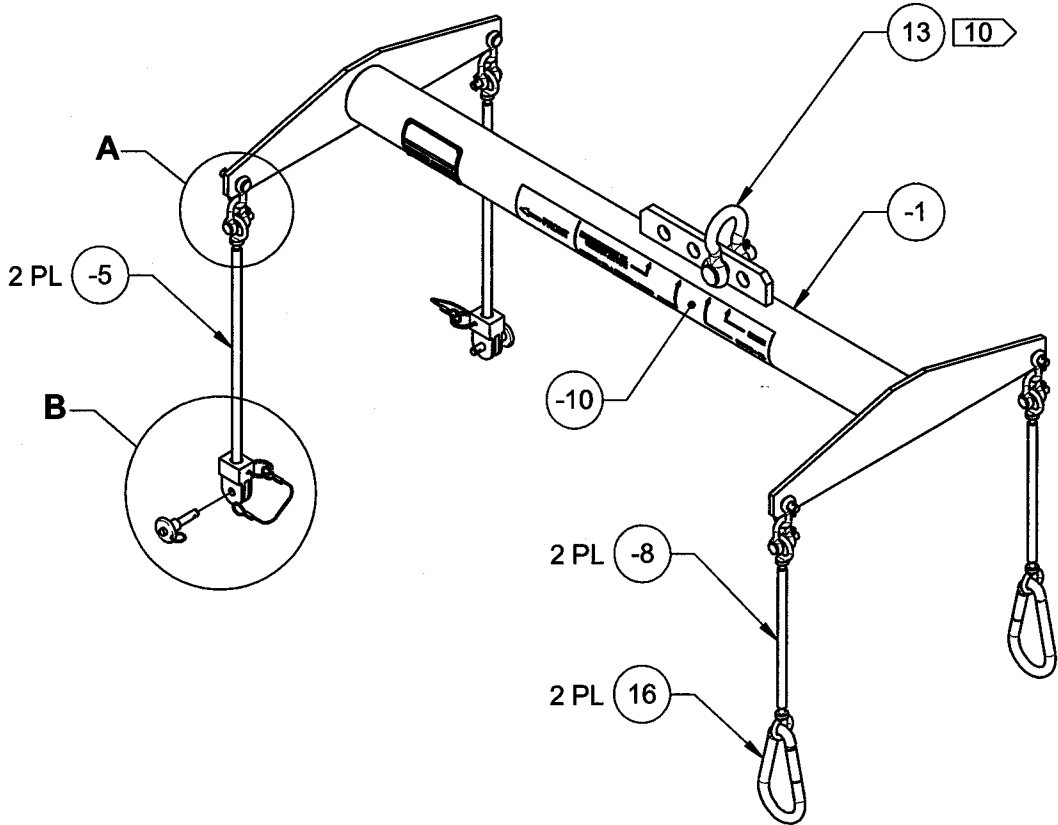
DETAIL A  
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RBE332A91-5490-00 MAKILA 2A SLING TOOL



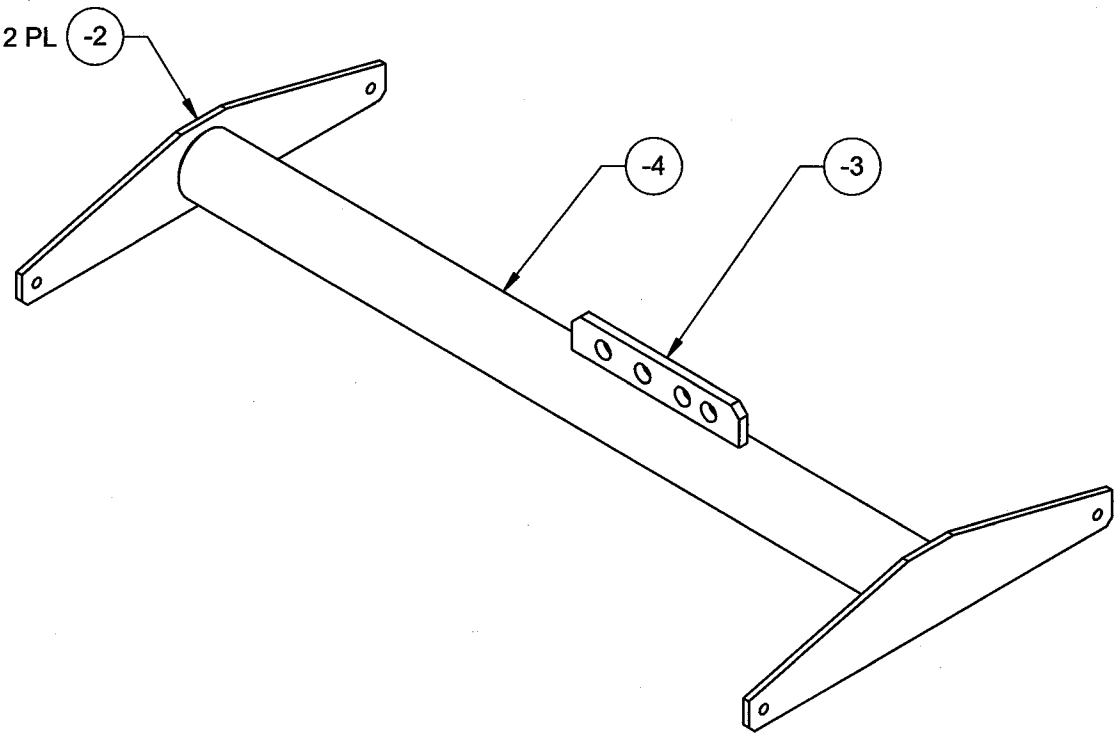
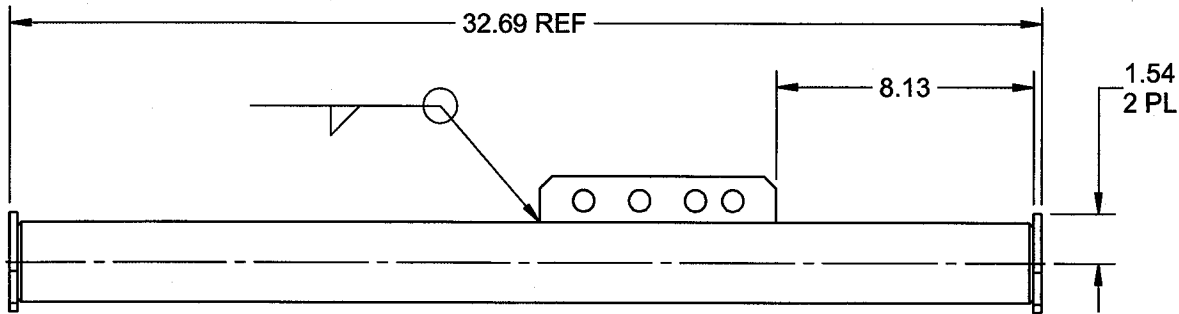
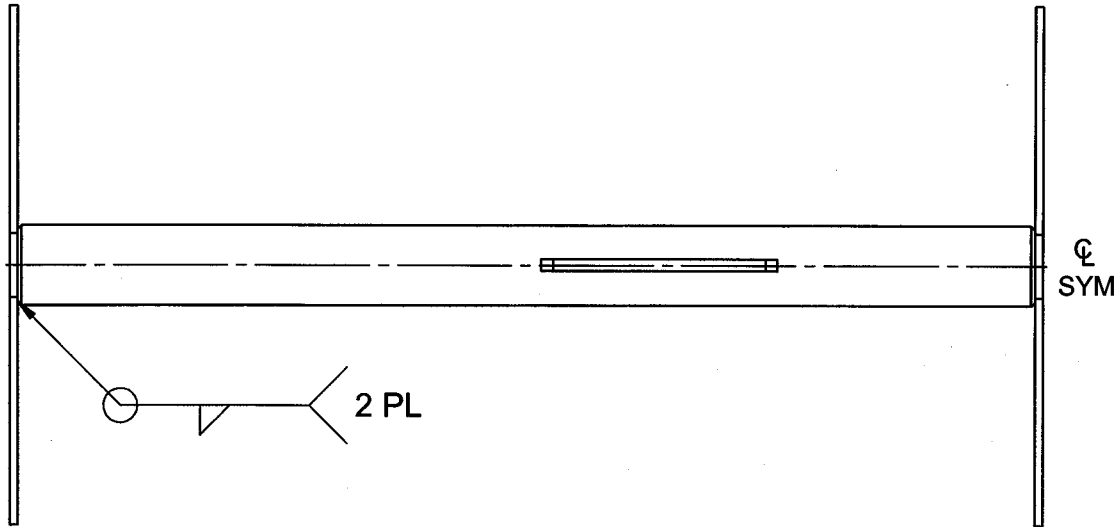
DETAIL B  
2 PL



- NOTES:
- 1) MATERIAL: N/A
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) IDENTIFICATION: ENGRAVE THE TOOL P/N, S/N, AND "SWL: 720 LBS" ON THE DART PLACARD WHERE INDICATED
  - 7) ASSEMBLE AS SHOWN
  - 8) FORM ITEM 11 TO OUTER DIAMETER OF ITEM -1 BEFORE INSTALLATION
  - 9) TRANSFER DRILL HOLES FOR ITEM 17 THROUGH ITEM -1 TO INSTALL ITEM 11
  - 10) BEND COTTER PIN PRONGS OF ITEMS 13 AND 14 AROUND SHACKLE PIN
  - 11) ASSEMBLED LANYARD LENGTH MUST BE 6" +/- 1", LANYARD MUST MOVE FREELY WHEN INSTALLING/REMOVING ITEM 12

A	SEE CAR 19-354 FOR DETAILED EXPLANATION OF CHANGES MADE	19-1027	KPT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA TOOL PART # <b>RBE332A91-5490-00</b> TITLE <b>MAKILA 2A SLING TOOL</b> REV. A SHEET 1 OF 12 SCALE NTS COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	KPT		
CHECKED	PM		
MFG. APPR.	DP		
APPROVED	W0		
DATE	1/10/2020		

ITEM #	QTY	PART #	PART TITLE
-2	2	RBE332A91-5490-00-2	END PLATE
-3	1	RBE332A91-5490-00-3	LIFT PLATE
-4	1	RBE332A91-5490-00-4	PIPE



**RBE332A91-5490-00-1 SLING WELDMENT**

NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: POWDERCOAT YELLOW QSI 005 OR MIL-PRF-24712  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) IDENTIFICATION: N/A  
7) ASSEMBLE AS SHOWN  
8) REMOVE ALL WELD SPATTERS

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	TOOL PART # <b>RBE332A91-5490-00</b>	REV. A SHEET 2 OF 12
DRAWN	KPT			
CHECKED	PM			
MFG. APPR.	DP			
APPROVED	<i>No</i>			
DATE <b>1/10/2020</b>		TITLE <b>MAKILA 2A SLING TOOL</b>		
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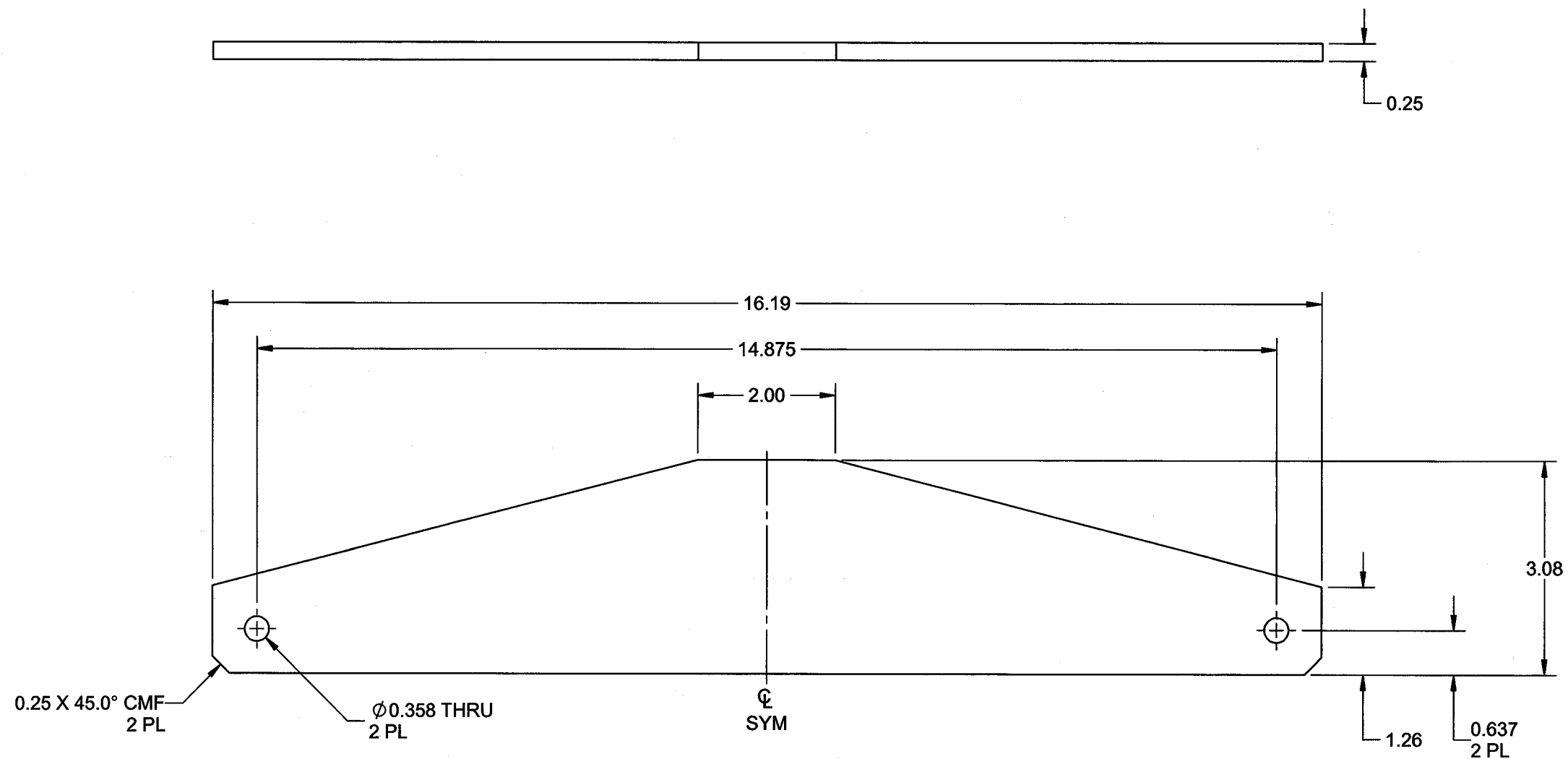
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**RBE332A91-5490-00-2 END PLATE**

**NOTES:**

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X =  $\pm 0.1$ " /  $\pm 1^\circ$   
X.XX =  $\pm 0.01$ " /  $\pm 0.5^\circ$   
X.XXX =  $\pm 0.005$ " /  $\pm 0.1^\circ$   
X.XXXX =  $\pm 0.0005$ " /  $\pm 0.05^\circ$   
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES =  $\pm 0.005$ "
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	TOOL PART # <b>RBE332A91-5490-00</b>	REV. A SHEET 3 OF 12
DRAWN	KPT			
CHECKED	PM			
MFG. APPR.	DP			
APPROVED	MS			
DATE 1/10/2020		TITLE <b>MAKILA 2A SLING TOOL</b>		
		SCALE NTS		
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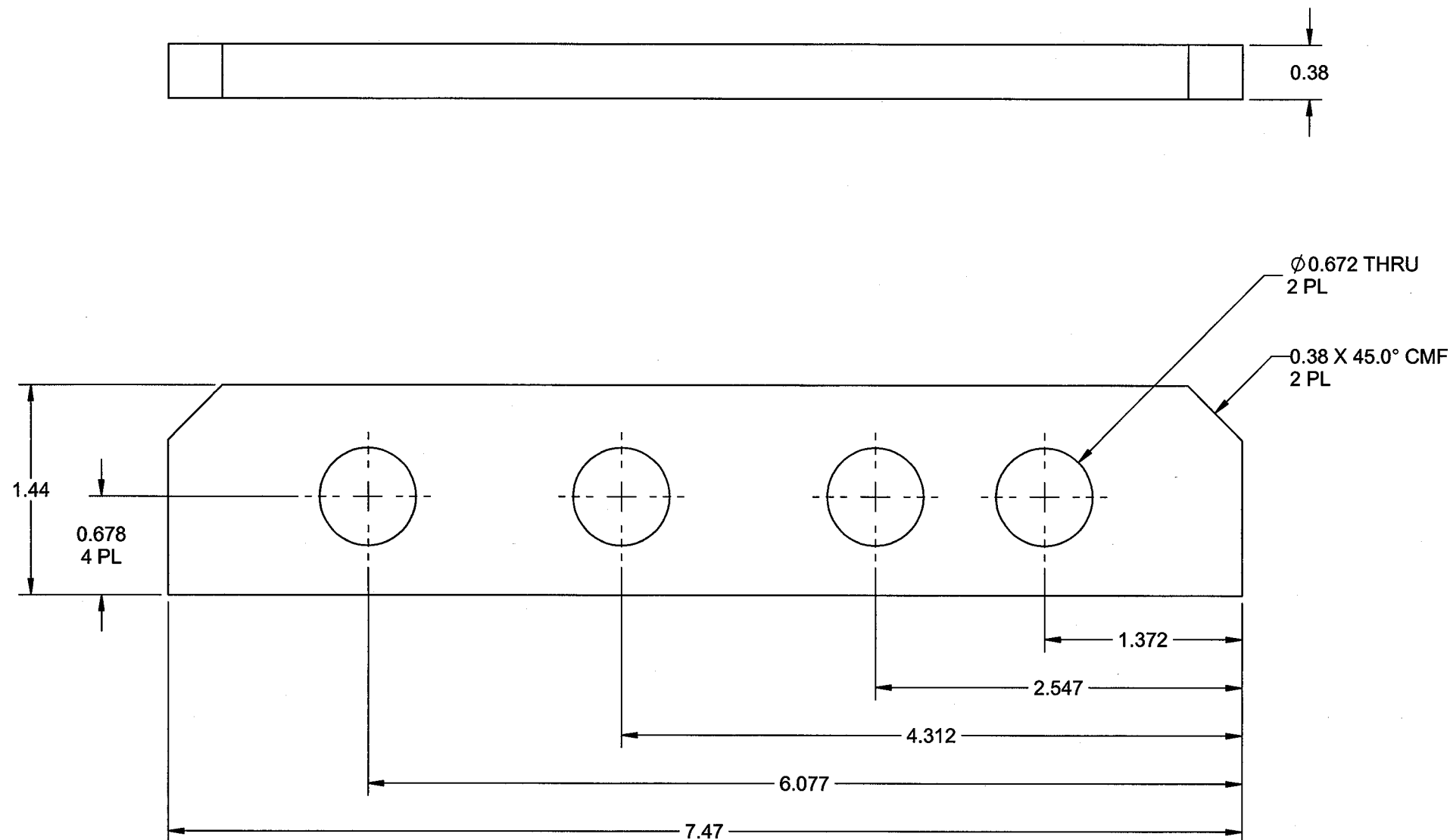
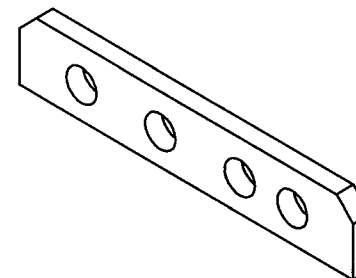
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**RBE332A91-5490-00-3 LIFT PLATE**

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X =  $\pm 0.1$ " /  $\pm 1^\circ$   
X.XX =  $\pm 0.01$ " /  $\pm 0.5^\circ$   
X.XXX =  $\pm 0.005$ " /  $\pm 0.1^\circ$   
X.XXXX =  $\pm 0.0005$ " /  $\pm 0.05^\circ$   
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES =  $\pm 0.005$ "
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	TOOL PART # <b>RBE332A91-5490-00</b>	REV. A: SHEET 4 OF 12
DRAWN	KPT			
CHECKED	PM			
MFG. APPR.	DP			
APPROVED	WQ			
DATE 1/10/2020		TITLE <b>MAKILA 2A SLING TOOL</b>		
SCALE NTS				
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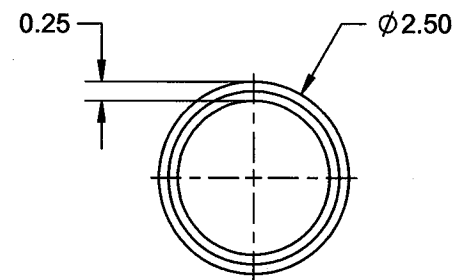
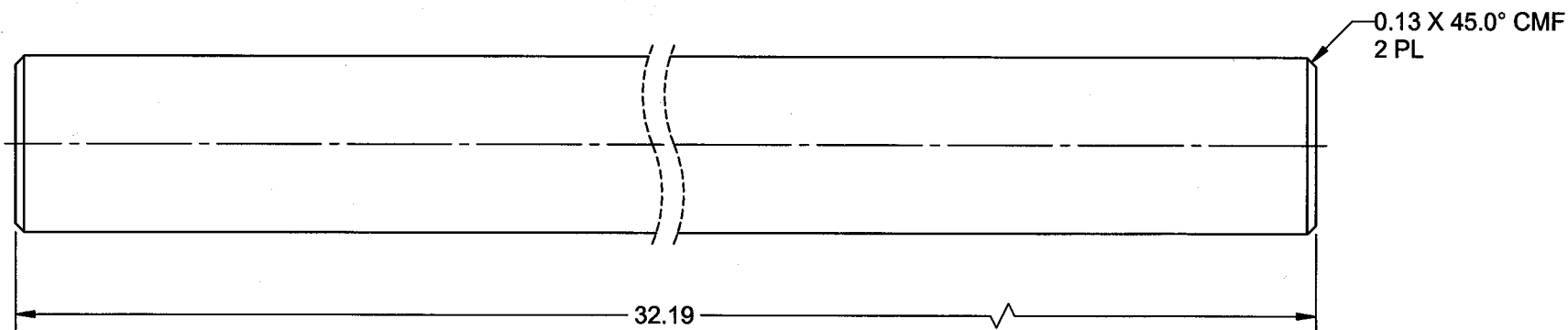
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**RBE332A91-5490-00-4 PIPE**

- NOTES:
- 1) MATERIAL: A519 CDS TUBING
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) REMOVE ALL SHARP EDGES AND BURRS
  - 7) IDENTIFICATION: N/A

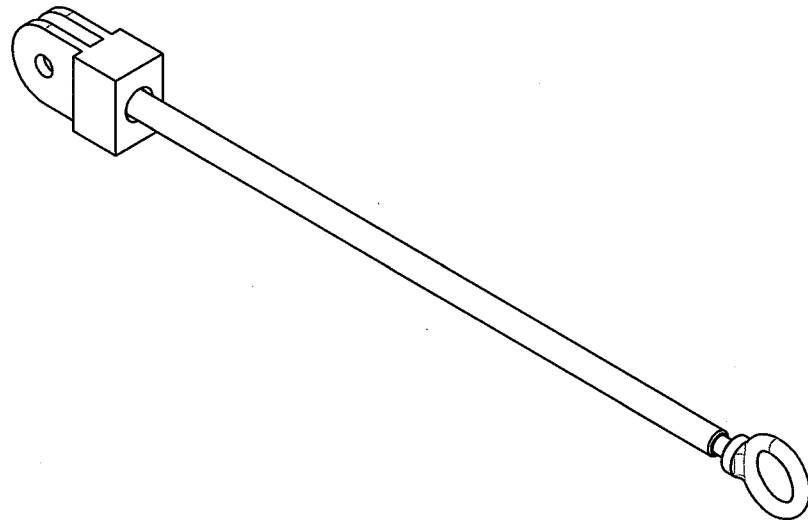
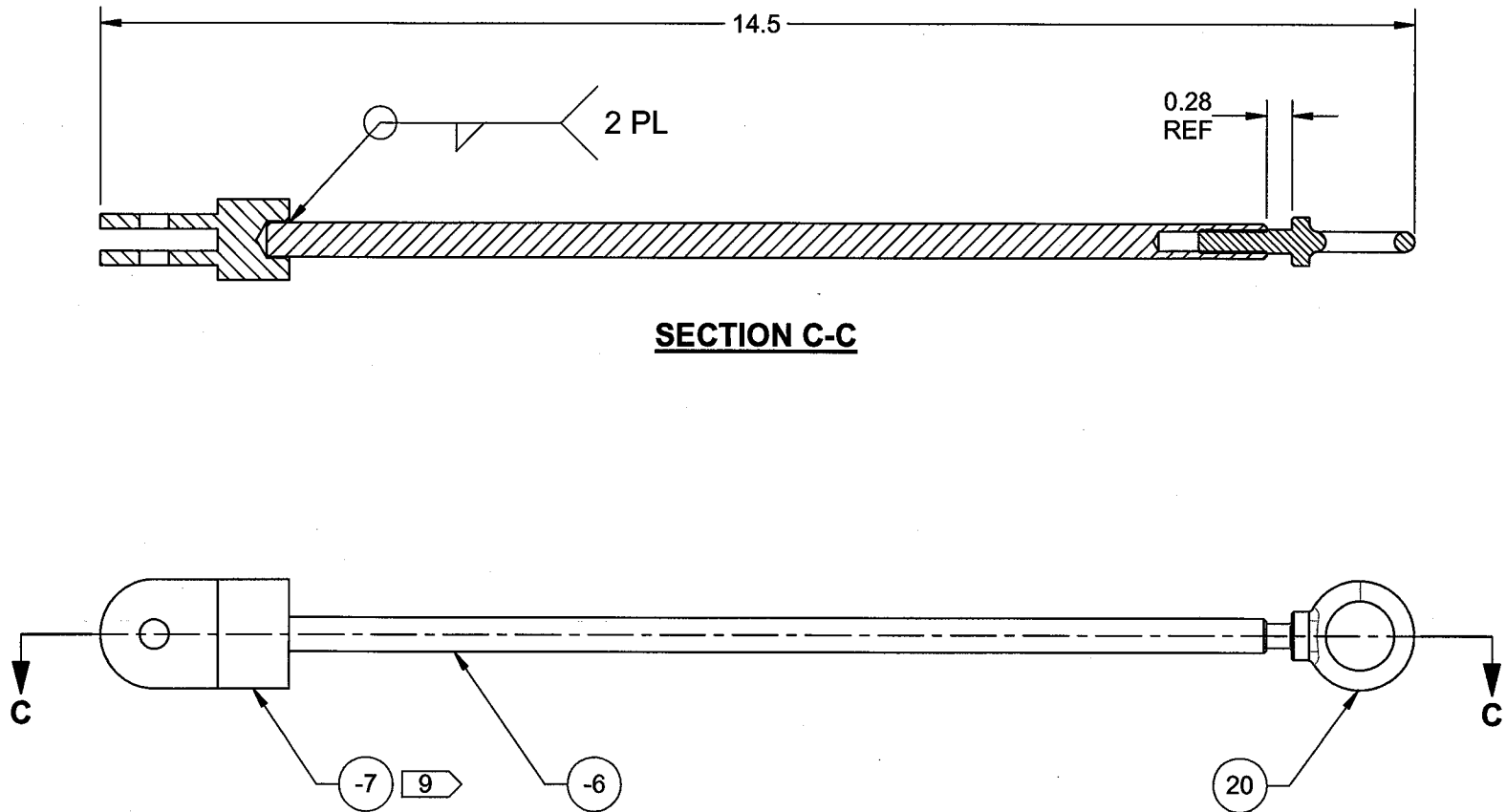
DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. A SHEET 5 OF 12					
DRAWN	KPT								
CHECKED	PM	TOOL PART # <b>RBE332A91-5490-00</b>		TITLE <b>MAKILA 2A SLING TOOL</b>					
MFG. APPR.	DP								
APPROVED	NO	DATE <b>1/10/2020</b>		SCALE NTS 					
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ITEM #	QTY	PART #	PART TITLE
-6	1	RBE332A91-5490-00-6	LEFT HAND ROD
-7	1	RBE332A91-5490-00-7	CLEVIS
20	1	MS51937-21	UNCOATED STEEL EYE BOLT 1/4"-28 X 1-1/32" SHANK LG.



**RBE332A91-5490-00-5 LEFT HAND ROD WELDMENT**

NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: POWDERCOAT YELLOW QSI 005 OR MIL-PRF-24712  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) IDENTIFICATION: N/A  
7) ASSEMBLE AS SHOWN  
8) REMOVE ALL WELD SPATTERS  
9) MASK HOLES AND SLOTS OF ITEM -7 PRIOR TO POWDERCOAT FINISH

DESIGN  
DRAWN  
CHECKED  
MFG. APPR.  
APPROVED  
DATE 1/10/2020

KPT  
KPT  
PM  
DP  
ND

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

TOOL PART #  
**RBE332A91-5490-00**

TITLE  
**MAKILA 2A SLING TOOL**

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REV. A  
SHEET 6 OF 12  
SCALE  
NTS

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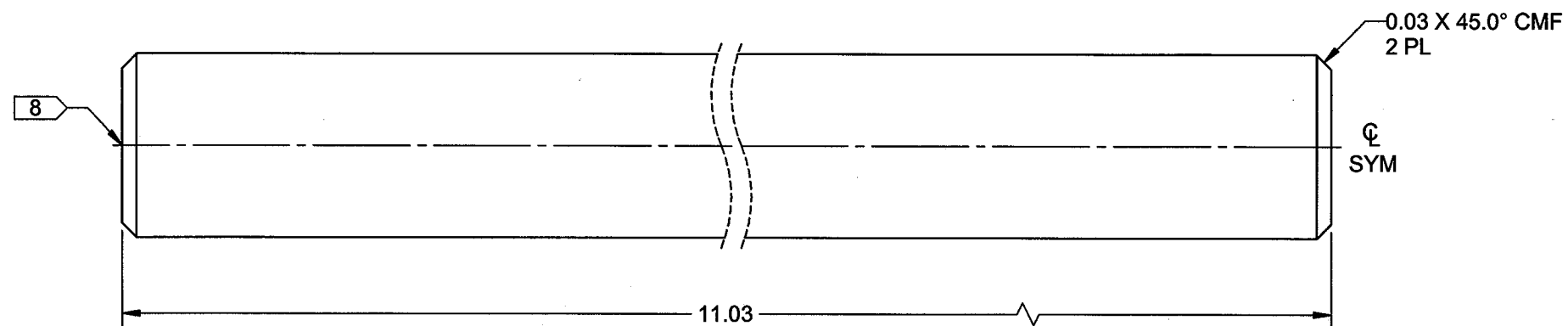
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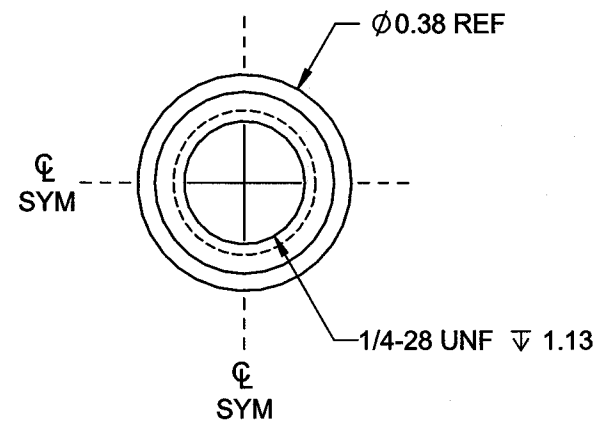
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**RBE332A91-5490-00-6 LEFT HAND ROD**



NOTES:

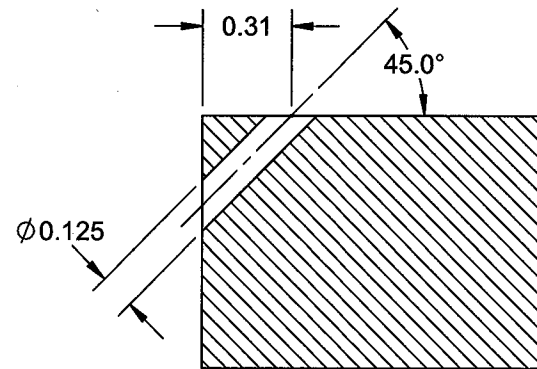
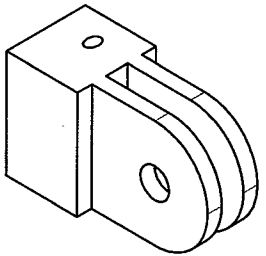
- 1) MATERIAL: McMaster#5252T315 OR EQUIV. (4140 ALLOY STEEL 3/8" DIA. ROD)
- 2) HEAT TREAT: 28-32 RC
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	KPT	<b>DART AEROSPACE LTD</b>		REV. A
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA		
CHECKED	PM	TOOL PART #	<b>RBE332A91-5490-00</b>	SHEET 7 OF 12
MFG. APPR.	DP	TITLE		
APPROVED	W	<b>MAKILA 2A SLING TOOL</b>		SCALE NTS
DATE	1/10/2020	COPYRIGHT © 2019 BY DART AEROSPACE LTD		
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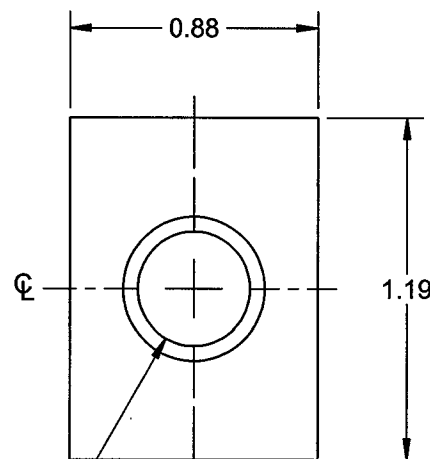
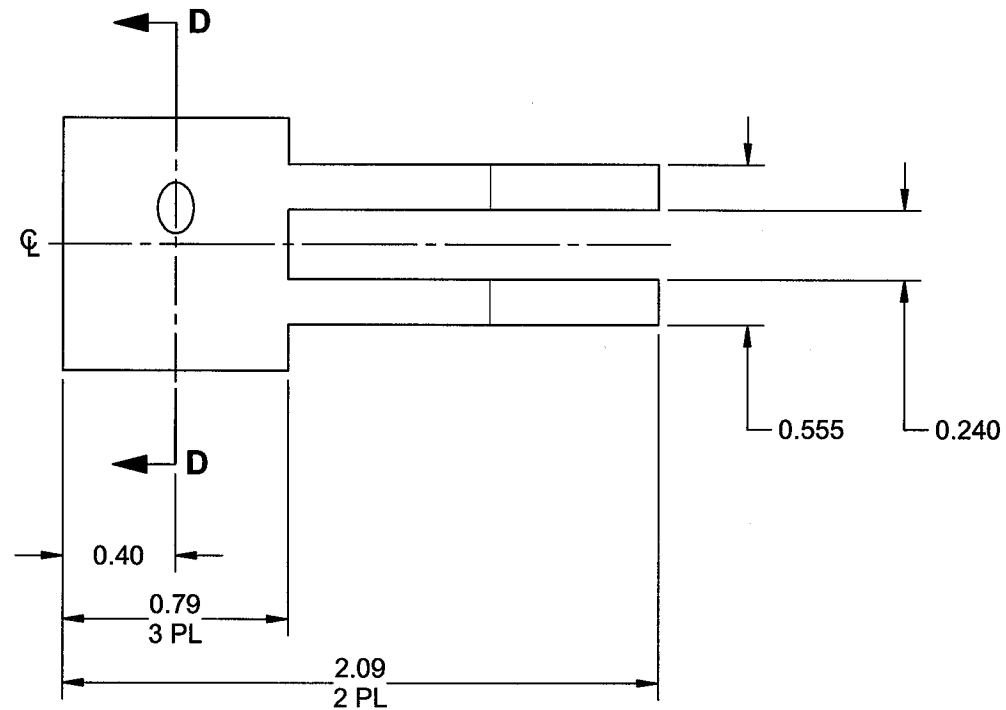
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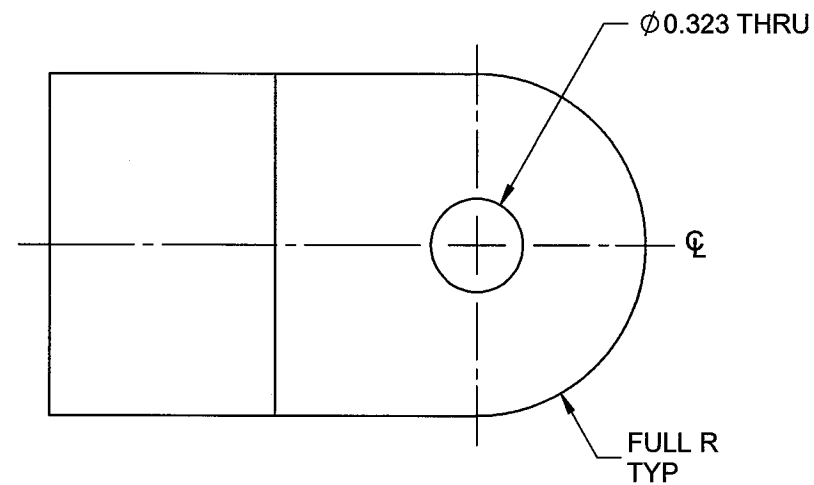
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SECTION D-D



✓  $\phi$  0.397  $\nabla$  0.25  
 $\phi$  0.50 X 90°, NEAR SIDE



RBE332A91-5490-00-7 CLEVIS

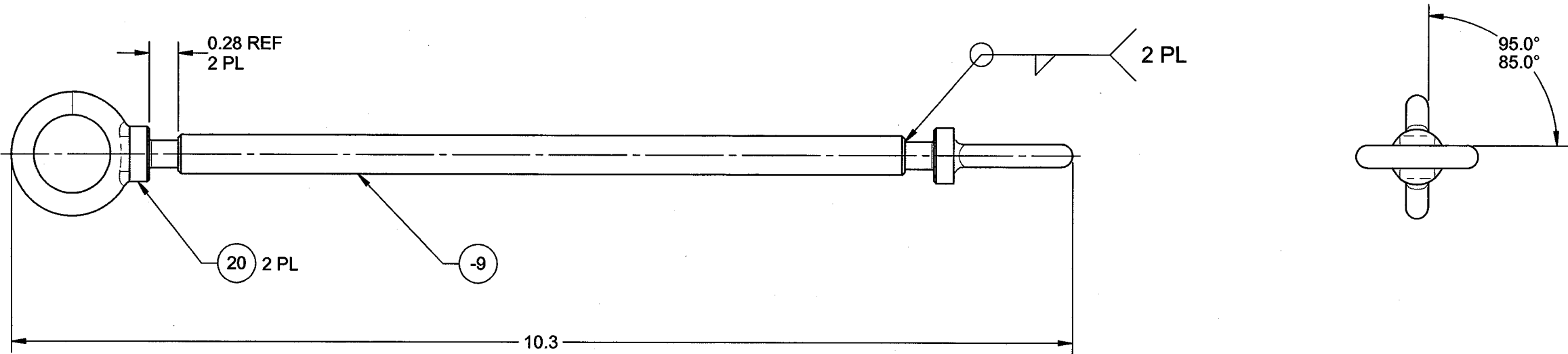
NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PM	TOOL PART #	REV. A
MFG. APPR.	DP	<b>RBE332A91-5490-00</b>	SHEET 8 OF 12
APPROVED		TITLE	SCALE
		<b>MAKILA 2A SLING TOOL</b>	NTS 
DATE	<b>1/10/2020</b>	<b>COPYRIGHT © 2019 BY DART AEROSPACE LTD</b>	
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ITEM #	QTY	PART #	PART TITLE
-9	1	RBE332A91-5490-00-9	RIGHT HAND ROD
20	2	MS51937-21	UNCOATED STEEL EYE BOLT 1/4"-28 X 1-1/32" SHANK LG.



**RBE332A91-5490-00-8 RIGHT HAND ROD WELDMENT**

NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: POWDERCOAT YELLOW QSI 005 OR MIL-PRF-24712  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) IDENTIFICATION: N/A  
7) ASSEMBLE AS SHOWN  
8) REMOVE ALL WELD SPATTERS

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. A. SHEET 9 OF 12
DRAWN	KPT		
CHECKED	PM		
MFG. APPR.	DP		
APPROVED	NO		
DATE	1/10/2020	TOOL PART # <b>RBE332A91-5490-00</b>	SCALE NTS
		TITLE <b>MAKILA 2A SLING TOOL</b>	
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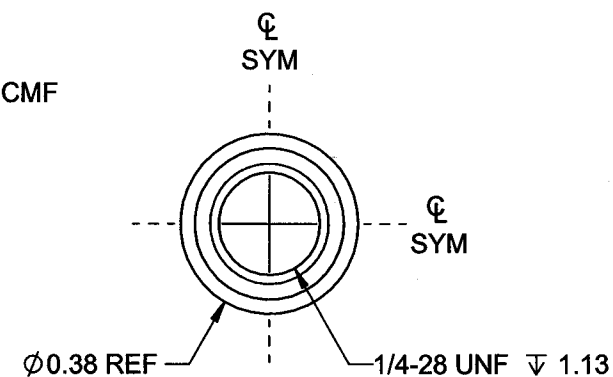
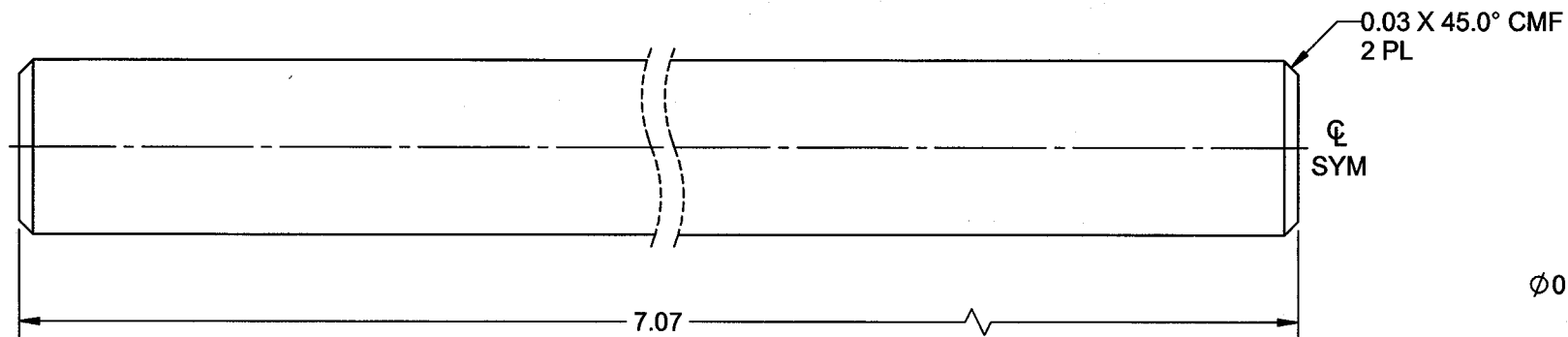
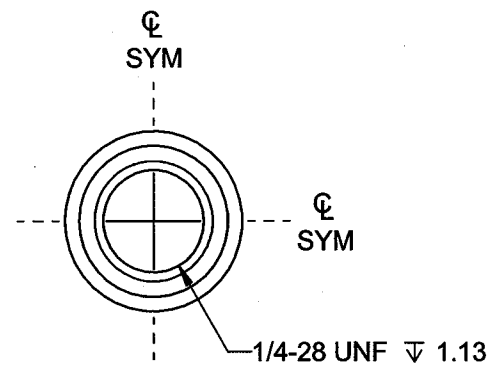
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**RBE332A91-5490-00-9 RIGHT HAND ROD**

**NOTES:**

- 1) MATERIAL: McMaster#5252T315 OR EQUIV. (4140 ALLOY STEEL 3/8" DIA. ROD)
- 2) HEAT TREAT: 28-32 RC
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PM	TOOL PART #	REV. A
MFG. APPR.	DP	<b>RBE332A91-5490-00</b>	SHEET 10 OF 12
APPROVED	<b>NO</b>	TITLE	SCALE
		<b>MAKILA 2A SLING TOOL</b>	NTS
DATE	<b>1/10/2020</b>	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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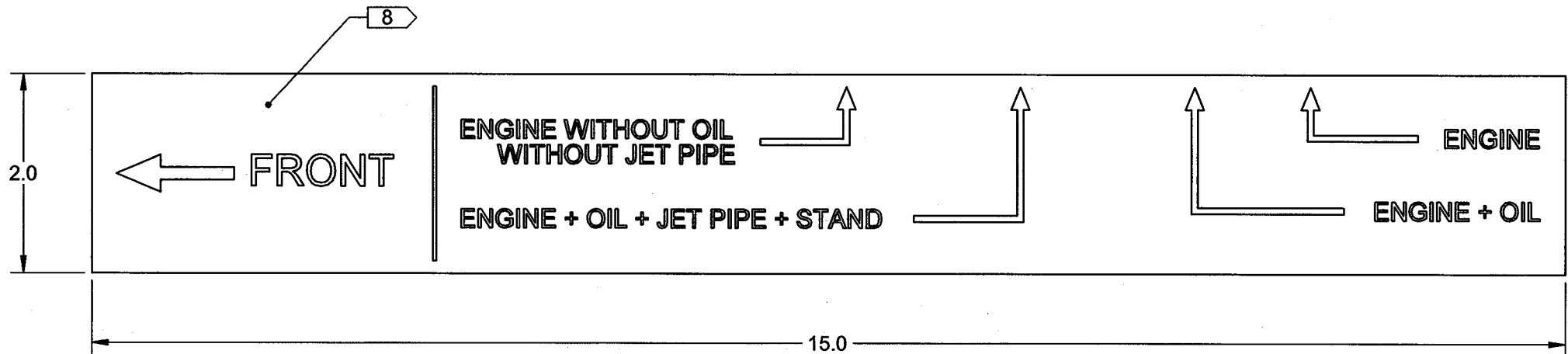
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**RBE332A91-5490-00-10 STICKER**

9

NOTES:

- 1) MATERIAL: 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031 OR EQUIV.
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) SILVER BACKGROUND WITH BLACK LETTERS AND ARROWS
- 9) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RBE332A91-5490-00-10 REV. A3.DXF

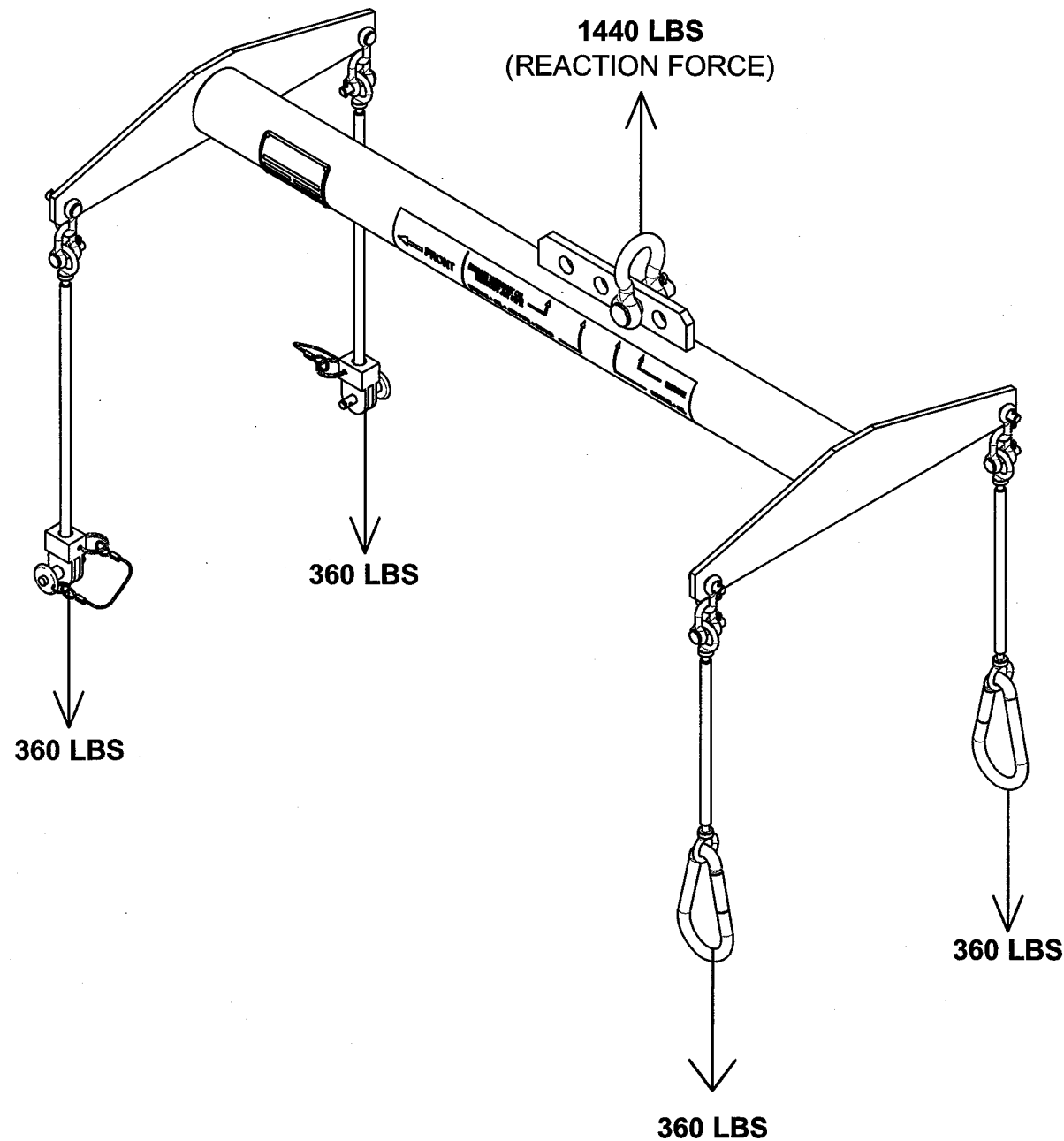
DESIGN	KPT	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PM	TOOL PART #	REV. A
MFG. APPR.	DP	<b>RBE332A91-5490-00</b>	SHEET 11 OF 12
APPROVED	NO	TITLE	SCALE
		<b>MAKILA 2A SLING TOOL</b>	NTS
DATE	1/10/2020	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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C

B

A



INSPECTION AND TESTING PROCEDURE FOR THE RBE332A91-5490-00 MAKILA 2A SLING TOOL. THIS ASSEMBLY SHOULD BE INSPECTED BEFORE EACH USE. REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED OF DAMAGE BEFORE USE.

FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE SLING ASSEMBLY ON AN OVERHEAD LIFTING DEVICE INTO. ATTACH SLING TO AN APPROPRIATE TEST WEIGHT OF 654 KG / 1440 LBS.
2. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTIONS, AND/OR DISTORTIONS
3. REMOVE WEIGHT AND RE-INSPECT SLING, CHECKING FOR CRACKS, DEFLECTIONS, AND/OR DISTORTIONS
4. REPEAT STEPS 1 TO 3 FOR "ENGINE WITHOUT OIL WITHOUT JET PIPE", "ENGINE + OIL + JET PIPE + STAND", AND "ENGINE" HOLE POSITIONS

INSPECTOR: \_\_\_\_\_  
TESTER: \_\_\_\_\_  
S/N: \_\_\_\_\_  
DATE: \_\_\_\_\_

DESIGN	KPT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	TOOL PART # <b>RBE332A91-5490-00</b>	REV. A
DRAWN	KPT			
CHECKED	PM			
MFG. APPR.	DP			
APPROVED	ND			
DATE 1/10/2020		TITLE <b>MAKILA 2A SLING TOOL</b>		
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